A1 .375

Work Order ID 70698

Monday, June 13, 2011 1:36:24 PM

Item ID: D3492-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Plug

Start Date: 6/13/2011 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 6/20/2011 **Req'd Qty:** 40.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 11-06-13 **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D3492 / D									
100	Hardinge CNC LATHE SMALL	0.00				40			
Hardinge	**Memo**	0.00							
Hardinge CNC Lathe Small	1-Turn as per Folio FA634 & Dwg D3492 Dwg Rev: A Folio Rev: N/A								
	JA 11/6/22								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				40			
QC	**Memo**	0.00							
Quality Control	JA 11/6/22								
120	QC8- Inspect parts - second check	0.00							
QC	**Memo**	0.00				40			
Quality Control	JA 11.6.22								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 70698

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab	Small Fab **Memo** 1-~~Deburr if neccesary~~ 2-~~Tumble~~	0.00 0.00	RQ 11-6-22			40			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	MAS						
150 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 **Memo**	0.00 0.00				40	BL 11-6-23		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 70698

Monday, June 13, 2011 1:36:24 PM

Item ID: D3492-5 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Plug

Start Date: 6/13/2011 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 6/20/2011 **Req'd Qty:** 40.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	(Flat End Only) START TIME: 2:45 OVEN TEMPERATURE: 320 0F FINISH TIME: 3:15								
M116464									
170	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: FP-B	0.00							
Packaging	**Memo**	0.00							
Packaging									

40 x Ø m-f 11/06/23

40 Ø BL 11-6-23

40 Ø m-f 11/06/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Work Order ID 70698

Monday, June 13, 2011 1:36:24 PM

Item ID: D3492-5 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Plug

Start Date: 6/13/2011 **Start Qty:** 40.00 **Cust Item ID:**

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00					11/6/24		
QC	**Memo**	0.00							
Quality Control									

MF
11-06-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, June 13, 2011 1:36:31 PM

Work Order ID: 70698

Parent Item: D3492-5

Parent Item Name: Plug

Start Date: 6/13/2011 **Required Date:** 6/20/2011

Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.375		Purchased	No			100	f	15.0000	0.06	2.526316			

6061-T6 Round Bar .375"

11/6/22

Location	Loc Qty	Loc Code
MAT012	15	
112567	15	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	7098
Description: Plug		Part Number:	D3492-5
Inspection Dwg: D3492	Rev: D		Page 1 of 1

11.06.14

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	Ø.374	✓		3A-9	
Ø0.188	+0.005/-0.001	Ø.185	✓			
0.045	+0.000/-0.002	.044	✓			
0.500	+/-0.010	.500	✓			
0.060	+/-0.005	.060	✓			
0.060	+/-0.005	.061	✓			
0.090	+0.000/-0.002	.089	✓			

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	11/6/22	Date:	11-6-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue P/O D3492-045	KJ/JLM	
B	06.10.16	Updated to Revision B	KJ/JLM	
C	07.10.30	Tolerance revised for Ø0.375	KJ/EC/DD	
D	08.11.28	Dwg Rev updated	KJ/EC	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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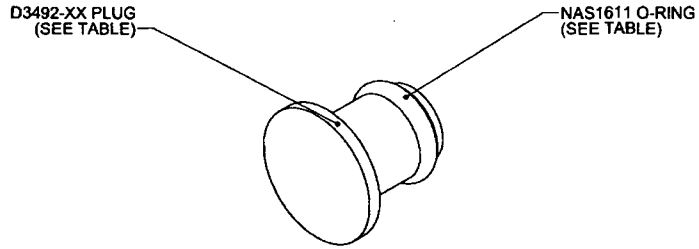
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70698

pd 11-06-13

D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

NOTES:
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED
2011 -05- 30

REV.	DESCRIPTION	BY	DATE
D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. REV. D
MFG. APPR.	JEB	D3492 SHEET 1 OF 2
APPROVED		TITLE SCALE
DE APPR.		PLUG 2:1
DATE	11.05.24	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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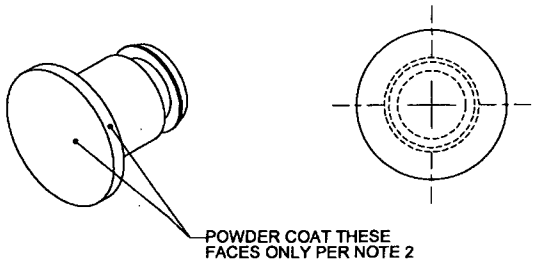
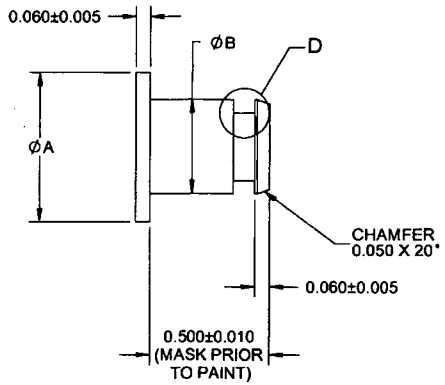
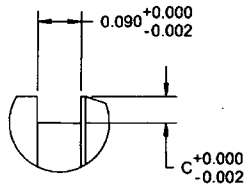




D3492-XX PLUG



DETAIL D

w/o 70648

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750

△D

△D

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100)
(REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

RELEASED
2011-05-30

DESIGN	PH	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AS	
CHECKED		DRAWING NO. D3492 REV. D
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE PLUG SCALE 4:1
DE APPR.		
DATE 11.05.24		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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